

Date: Thursday, 24/07/2008 3:13:55 PM
User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D206-558-041	<p><i>SPLIT 6</i></p> <p><i>(S)</i></p> <p><i>SPLIT</i></p> <p><i>18</i> Um: Each</p>
Job Number : 40748-3		
Estimate Number : 10804		
P.O. Number :	Part Number : D206558041	
This Issue : 24/07/2008 S.O. No. :	Drawing Number : ECN08-504	
Prsht Rev. : NC	Project Number :	
First Issue : / /	Drawing Revision :	
Previous Run : 00015	Material :	
Written By :	Due Date : 05/08/2008	
Checked & Approved By :		
Comment :		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

3X D206-558-041 B38580 ✓ FFx3 08-07-30

PULL FROM STOCK:

3 X D206-558-041 B39281

10 X D206-558-041 B39398 ✓

5 X D206-558-041 B39399 ✓

FFx10 } 08-07-30
FFx5 }

2.0	D206558041	Single Cargo Mirror Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 18.0000 Each(s)

Single Cargo Mirror Assembly

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

CUT ARMS TO REMOVE ALL COMPONENTS

D2011-101 MIRROR

D2052 MTG BRKT

D2054 BUSHING

D2055 CLAMP

D2056 BELL CRANK

D2057 PLUG

PUT COMPONENTS ASIDE TO RE-USE WITH NEW ARM

DISCARD HARDWARE

MANUFACTURE NEW ARMS WITH .049 WALL MAT'L

FF 08-07-30

— FF 08-07-30

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 40748

Part Number: D206558041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

M304TR0500W049

304 RD Tube .500 x .049W



Comment: Qty.: 1.7500 f(s)/Unit Total: 31.5006 f(s)

304 RD Tube .500 x .049W

304/316 SS Seamless Tube (Ref QSI 017 4.1.1.2) as per Dwg D2065 using punch Jig DT8012

(M04TR0.500W049)

Identify as D2065.

Note: 1 end only

Batch

108324

M 108324

FF 08-07-31

(8)

(10)

take 10x D2065 from B 40580

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Punch 1/2" OD x .035" Wall AISI

Spaced for SR.

FF

08-07-31 - (10)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Cut to length as per Dwg D2065

Bend as per Dwg D2065 and template D2065T1

Flatten the end on Hydraulic press using Dt 8545

Drill 00.188" holes as per Dwg D2065 and template D2065 T1 and using Dt 8768 Drill Jig.

Deburr.

FF 08-07-31

FF 08/09/11

(10)

(1)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/09/11 @

08/07/31

(+10)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:00
320
11:30

M-H

08/07/31

(10x)

M 102316

M

08-09-11

(X)

M 102316 08-09-12

(X)

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Job Number:



Seq. #:

Machine Or Operation:

Description:

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D206-558

USING ORIGINAL COMPONENTS
AND NEW HARDWARE:

11.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 72.0000 Each(s)
Washer 36

Pick:

Qty Part Number

Description

Batch

4 AN960JD10

Washer

M100550

12.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 36.0000 Each(s)
Nut 18

Pick:

Qty Part Number

Description

Batch

2 MS21042L3

Nut

M107665

or MS21042-3

13.0

MS27039118

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 36.0000 Each(s)
Screw 18

Pick:

Qty Part Number

Description

Batch

2 MS27039-1-18

Screw

M100161

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

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Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR
ORIGINAL KITS TO BE INCLUDED.

Jul 09.12 ①
7012 @ chg 007

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
REPACKAGE PER PPP
USING NEW B/N @ CHG 007
NEW LABELS REQUIRED
ADD PAPERWORK DSI 9416

① Jul 08.9.12
Rev H
NS-8/09/12.

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-12

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D2065 ARM

RELEASED
08-07-23-17

C	REDRAWN IN SOLIDWORKS, INCORPORATED REV. B1 (FINISH ADDED VIA HAND CHANGE) (ZN A6-2); ADD D2065F CUT LENGTH DETAIL FOR D2065 (ZN B3-2); ADD R1.50 DIMENSION (ZN D5-2); Ø0.500 X 0.049 WALL WAS Ø0.500 X 0.035 WALL (ZN A5-2); REASON: Ø0.500 X 0.035 WALL TUBING USED ON D2010 IS CRACKING DURING SERVICE	PH	08.06.13
B	RE-DESIGN	BW	96.02.06
A	NEW ISSUE	BW	92.03.12
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2065 TITLE ARM REV. C SHEET 1 OF 2 SCALE NTS COPYRIGHT © 1993 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	
DRAWN	PH		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	08.06.13		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

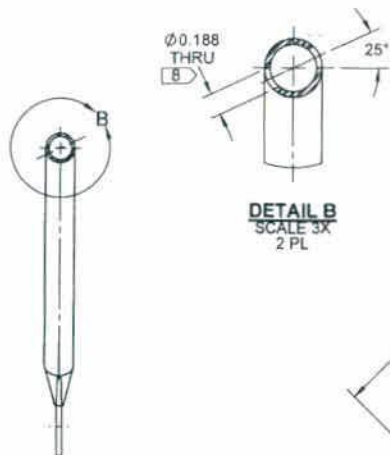
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

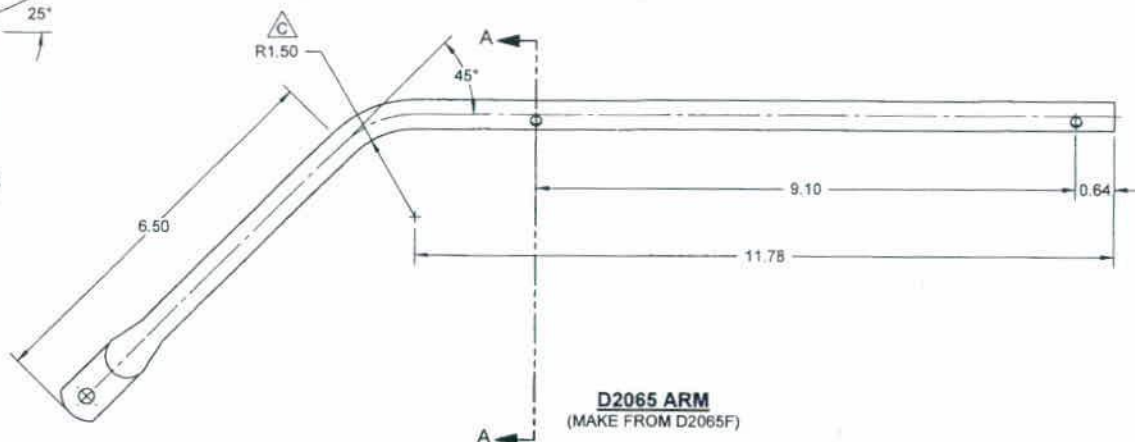
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



SECTION A-A



D2065 ARM
(MAKE FROM D2065F)



D2065F ARM CUT LENGTH DETAIL

NOTES

- 1) MATERIAL: D2065F: AISI 304/316 SS SEAMLESS ROUND TUBING, $\phi 0.500 \times 0.049$ WALL (REF DART SPEC M304TR0.500W.049)
- 2) FINISH: POWDER COAT BLACK SANITEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.41 lbs
- 8) DRILL $\phi 0.188$ AFTER BENDING

RELEASED
08.06.13

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2065	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ARM	NTS
DATE	08.06.13	COPYRIGHT © 1992 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. PHOTO SUPPLIED ON THE ASSUMPTION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OTHER THAN THOSE FOR WHICH IT WAS PROVIDED WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

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8/2/81	# 10.0	During Disassembly He 22057 Plugs were not saveable Due to the inside Decal the tubing changing	 J. Smith	Scrap all Plugs with Arms and Real Pull from stock B# 340040	08/07/31 FF	 08/07/31 FF	 J. Smith	 08/07/31

NOTE: Date & initial all entries

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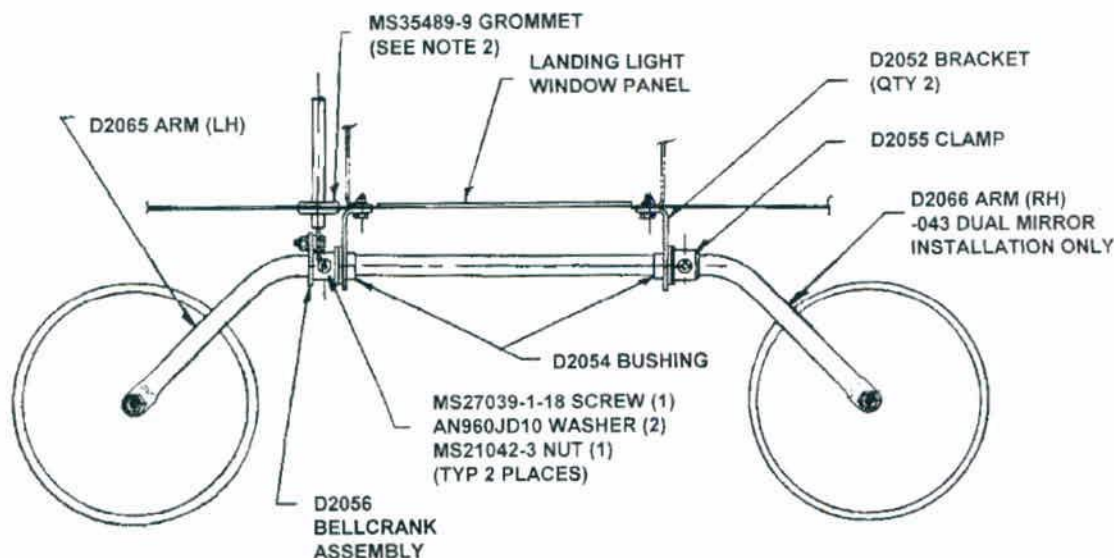


Figure 25.2 - View A: Looking Aft.
(D206-558-043 Mirror Shown)

REFERENCE ONLY

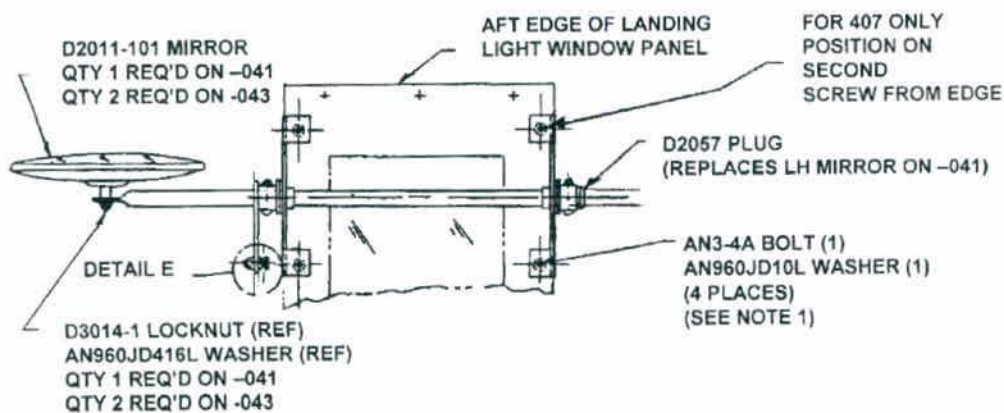
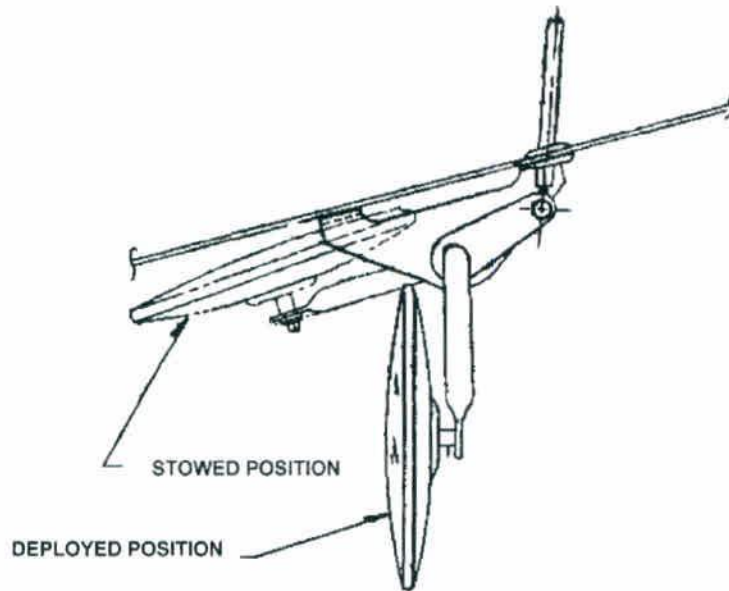


Figure 25.3 - View C: Looking Down on Mirror Installation
(D206-558-041 Mirror Shown)

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25-00-00



REFERENCE ONLY

Figure 25.4 – Detail D: Looking from Side on Mirror Installation
(D206-558-041/-043 Mirror Shown)

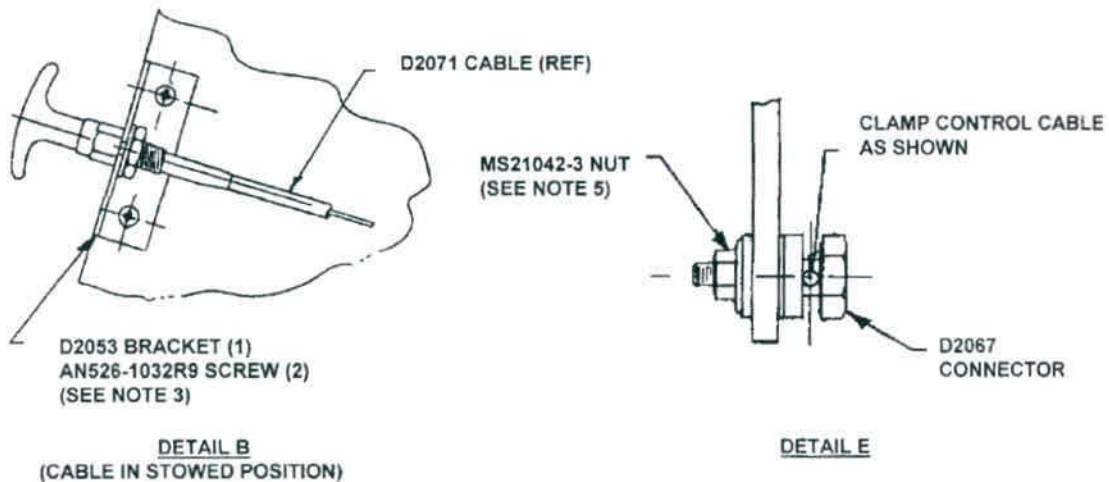


Figure 25.5 – Details B and E on Mirror Installation
(D206-558-041/-043 Mirror Shown)

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